Work Order II Tuesday, November 0-			*126	3301*							Page 1
Item ID: D346 Revision ID:	52-1		Accept	*N900	0040	110	N *	Setup	Start	*N	S1*
Item Name: Brack	xet Assembly								Stop	*N	S2*
Start Date: 11/4/ Required Date: 11/4/ Reference:		*6* *6*		Cust Item Customer:							1. 1.
Approvals: Prod	cess Plan: MLJ	Date: 14-11-04	Tooling:	D	ate:			Run	Start	*N	R1*
QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reje		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr				-1						
D3462	Rev C										
¹⁰⁰ *1∩∩ *	FLOW WATER JET		0.00		*		(<u>8</u>)			in, 14	/11/26
Waterjet FLOW CNC Waterjet 64.125	Memo 1-Cut as p Dwg Rev:	er Dwg D3462	0.00								1 126
	Prog Rev: 2-Deburr	if necessary									
¹¹⁰ *11∩*	QC2- Inspect parts off	machine FAI/FAIB	0.00				(8)		0	1	1
QC	Memo		0.00				(8)		EL	/a14	11/26

0.00

Memo

Quality Control

DQA:		_ Date:			MORK ORDER MON			DRAANCE / LIDDA	TE	-			7
QA Closed:		Date:			WORK ORDER NON-	-C(JNFO	RIVIANCE / UPDA		ork Order up	date only	AEROSPACI	Ē
· ·					DISPOSITION			Α		PARTMENT/			
Work Orde	er:				r					1		-	
Part N	lo				Rework Scrap			Machining Sr	osstube mall Fab		Water Jet d. Eng. Coor.	Engineering Quality	
NCR N	lo				Use-as-is Suspected Unapproved		Therr	~ 	inishing mposite	Rec/Stor	e/Packaging Supplier	Other	
Root				Desci	ription of work order update		nitial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector	
Design													
Doc/Data		:											
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier	\neg												
Training													
Transport													
Unapproved								,					
· · · · · ·						FAI	ULT CA	TEGORY					
Landir	ng Gear				General			-	"				
ſ	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
	Centre N	lot Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	t T	Temperature/Cure	
ľ	Crimp/K	ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unquali	ified	Part Lost/Mi	ssing	Weld	
Ì	Cuffs				Contamination		Instruct	tions Incomplete/Unclea	ar	Part Moved	_	Wrong Stock Pulled	
	Crushing	;			Countersink		4	gned/off center		Positioned W	rong ∟	_	
	Heat Tre				Cut Too Short		Mislab			Power Loss/S		Other	
	Inspection	on Strip in	Tube		Drawing		Misrea		<u> </u>	. ·	- L		
	Marks/C				Drill Holes		Off-set						
		Sequence			Finish		1	Calibration			-		_
ľ		wist in Tul			Fit/Function		1	Sequence					

Work Ord					*126	3301*							Page 2
Item ID: Revision ID: Item Name:	D3462-1 Bracket Asser	mbly		A	Accept	*N900	1040	1100	ገ*	Setup	Start Stop	*N	
Start Date: Required Date: Reference:	11/4/2014	Start Qty: 6.00 Req'd Qty: 6.00		*6* *6*		Cust Item :					Stop	×N	S2*
Approvals:	Process Pla	nn:	_ Date: _ Date:		Tooling:		Pate:			Run	Start Stop	*N	
Sequence ID/ Work Center II 120 *1 20* QC Quality Control		Operation Description QC8- Inspect parts - seco			SPC (Y/N): Set Up/ Run Hours 0.00 0.00	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty	ect F	Reject Number	Insp. Stamp DAS 38 9-88 NOV 2 7 2014
*150 *150* Packaging Packaging		Identify as per dwg & Sto Memo *****STOCI	ock Location:		0.00				B		14	-11-0	27 m,
160 *160* QC Quality Control		QC21- Final Inspection -	Work Order R	elease	0.00						14	12	128

A94-11-27

DQA:		<u>.</u>	Date:			WORK ORDER NON-	-00	NEO	RMANCE / HI	DDATE				DART
QA Closed:			Date:			WORK ORDER HOR			WINITEL / OI		ork Order up	date only		AEROSPACE
Work Orde	er:					DISPOSITION	,	-		AGAINST DE	PARTMENT	PROCESS		
Part N	- lo					Rework Scrap Use-as-is Suspected Unapproved		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Desci	ription of work order update		nitial	Act	ion	Sign &			
Cause	ŀ	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	ı	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	10													
					_		FAL	JLT CAT	regory					· · · · · · · · · · · · · · · · · · ·
Landir		ear Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea nspection Marks/Ch Furning So	ik/Ripple t n Strip in atter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/Ur ions Incomplete/U ned/off center eled	· —	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	tolerance et ssing Vrong	Se Te W W	essure/Forced et-up emperature/Cure feld frong Stock Pulled
•	_	Wave/Tw				Fit/Function		i	Sequence					

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Page 1

Work Order ID: 126301

126301

Parent Item:

D3462-1

D3462-1

Parent Item Name: Bracket Assembly

Start Date: 11/4/2014

Required Date: 11/4/2014

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV. A 05.11.18 NEW ISSUE

IPP Rev:B Now on Waterjet 06-06-16 JLM

esr rev B 08.07.15 ecn 1049 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Prima Item Locati	•	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M304S11GA		Purchased	No		100	sf	294.2990	0.095	1		
M304S11 304/316 0.125 Sheet	IGA							**	1		DC 14/11/26

Location Loc Qty Loc Code MAT020 254.299 27.3 83.13 143.869 TPI

39.9999604 M129545 39.9999604

DQA:		_ Date:				•						
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT				AEROSPACE
QA Closed:		Date:							Wo	ork Order up	date only	
Work Orde	er:				DISPOSITION			AG	GAINST DEI	PARTMENT	PROCESS	
		/			Rework			Skid-tube Cros	sstube		Water Jet	Engineering
Part N	lo.				Scrap			—	all Fab	Pro	d. Eng. Coor.	Quality
·					Use-as-is		Thern	noforming Fir	nishing	Rec/Stor	e/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab Com	posite		Supplier	
Root				Desci	ription of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design				:								
oc/Data												
quip/Tooling					•							
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perator	_	ľ			•	İ						
Offset/Setup	_		·					,				
rocess	-											
upplier								•	:			
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ransport Inapproved								·				
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Landir	ng Gear				General	17.	OLI CA	ILOOKI				
[Bending				Bend		l _{Folio/P}	Program		Outside Dim	ensions [Pressure/Forced
	Centre N	ot Concei	ntric		BOM/Route		Grain	6		Over/Under		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorrec		Temperature/Cure
Ī	Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualifie	ed	Part Lost/Mi	ssing	Weld
Ī	Cuffs				Contamination		1	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
Ţ	Crushing			ļ	Countersink		Misalig	ned/off center		Positioned W	/rong	
	Heat Trea	at	•		Cut Too Short		Mislabe	eled		Power Loss/S	Surge	Other
	Inspectio	n Strip in	Tube		Drawing		Misread	t				
[Marks/Ch	natter			Drill Holes		Off-set					
	Turning S	equence			Finish		Out of (Calibration				
	Wave/Tw	vist in Tub	oe		Fit/Function		Out of	Sequence				

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D3065-5DART AEROSPACE LTD	Work Order:	126301
Description: Base	Part Number:	D3462-1
Inspection Dwg: D3462 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

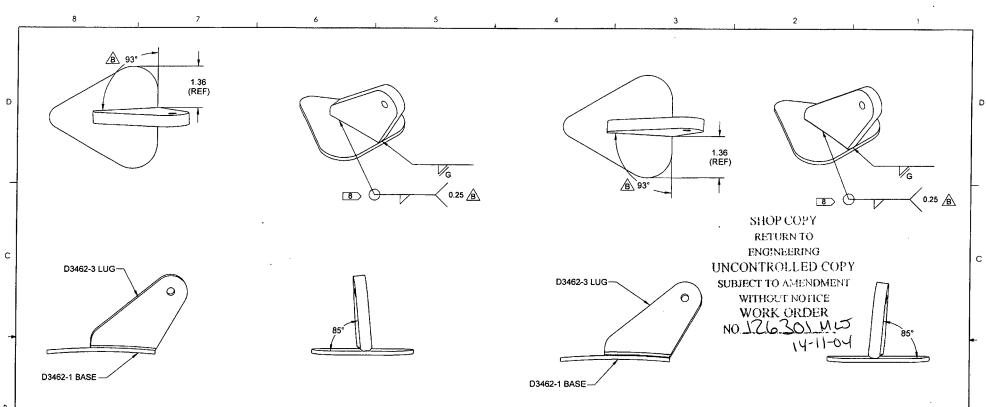
	r					
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.58	+/-0.030	3.588			V= Dr-02	
3.36	+/-0.030	3.360		1		
0.125	+/-0.010	. 116				
			 			
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		L	DAS			

			38		
Measured by: 0 / 12	,	Audited by:	9-89	Prototype Approval:	N/A
Date: /4///	26	Date:	NOV 2 7 2014	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.09.06	New Issue	KJ/JLM 1.0	
В	08.07.24	Dimensions updated per Dwg Rev C	KJ/DD O	N.

DQA:	- · · · <u>- · · · · · · · · · · · · · · ·</u>	Date:											74	NA PT
		5 .			WORK ORDER NON-	-CC	ONFO	RMANCE / U	PDATE					AEROSPACE
QA Closed:		Date:					ř			W	ork Order up	odate only		
Work Orde	er:				DISPOSITION			`	AGAINST	DE	PARTMENT	/PROCESS		
					Rework			Skid-tube	Crosstube	ſ]	Water Jet		Engineering
Part N	lo.				Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor.	\exists	Quality
					Use-as-is			noforming	Finishing	_	4	re/Packaging	┪	Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite]	Supplier		
Root	1	1		Descr	iption of work order update		Initial	Λct	tion		Sign &		_	
Cause	Date	Step	Qty	Desci	or non-conformance	l	nief Eng		ription		Date	Verification		QC Inspector
Design	Date	Step	Qty		of fion-comormance	Cit	nei riig	Desci	ірціон		Date	vermeation	┧	QC IIIspector
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material													1	•
Operator													ŀ	
Offset/Setup											Ġ.		İ	
Process										.5				
Supplier		į									ئىن ئىلا			
Training														
Transport														
Unapproved						<u> </u>								
· · · · · · · · · · · · · · · · · · ·						FA	ULT CAT	EGORY						
Landir	ng Gear				General		1				7	_		
	Bending				Bend		1	rogram			Outside Dim	<u> </u>	\neg	Pressure/Forced
	Centre No	ot Conce	ntric		BOM/Route		Grain				Over/Under	} −	\dashv	Set-up
	Cracks		6	_	Broken/Damage/Defect		Hardwa				Part Incorred) -	-	Temperature/Cure
	Crimp/Kir	nk/Ripple	:/Wave		Burrs		1	on Incomplete/Ur			Part Lost/Mi	ssing	\dashv	Weld
	Cuffs			<u> </u>	Contamination	_	4	ions Incomplete/U	Jnclear	\vdash	Part Moved	<u> </u>		Wrong Stock Pulled
ļ	Crushing			<u> </u>	Countersink		1 -	ned/off center		_	Positioned W			
	Heat Trea		T. d		Cut Too Short	\vdash	Mislabe			L	Power Loss/S	Surge		Other
	Inspectio		rupe	-	Drawing Drill Holos		Misread	1						
	Marks/Ch				Drill Holes	\vdash	Off-set	Calibratio -				<u> </u>		
}	Turning S			-	Finish Fit/Function	<u> </u>	1	Calibration						
<u></u>	Wave/Tw	rist in Tul	ne.		rigrunction		Out of S	Sequence						1

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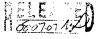


D3462-041 BRACKET ASSEMBLY

2TY -041	-042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042"
 USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.75 lbs (TYP)
 8) WELDING: PER DART QSI 004

D3462-042 BRACKET ASSEMBLY



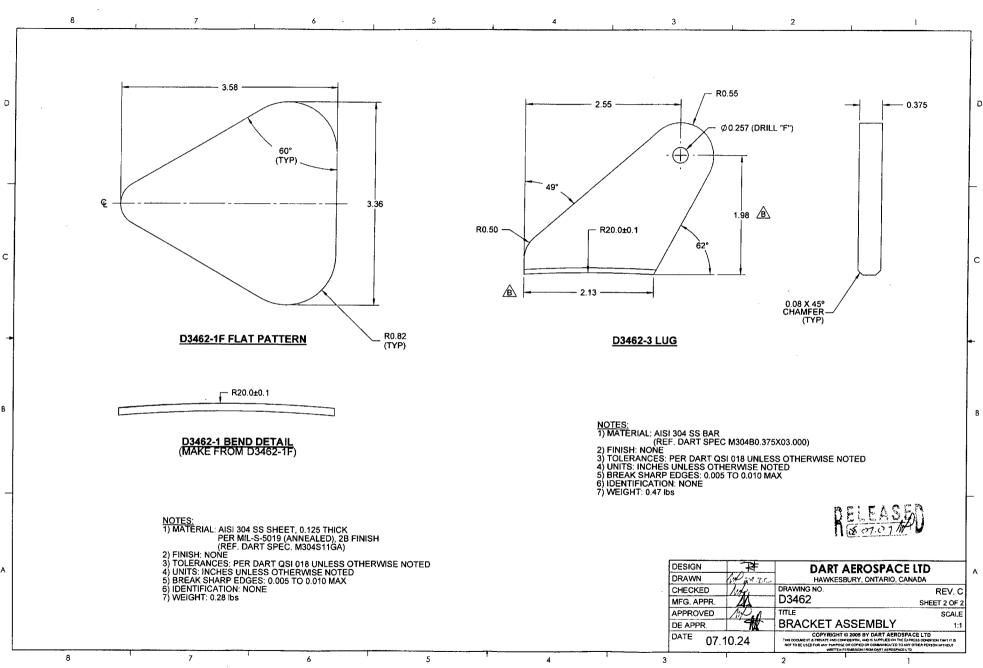
DESIG	N A	DART AFROSPA	ACEL	TD
REV.	DESCRIPTION	BY	DATE	
Α	NEW ISSUE	RF	05.09.20	
В	REVISE DIMENSIONS	RF	05.12.05	
С	SHOW VIEWS OF D3462-04 REASON: PRODUCTION FA	DC	07.10.24	

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
DRAWN	MARDO							
CHECKED	NP	DRAWING NO.	REV. C					
MFG. APPR.	200	D3462	SHEET 1 OF 2					
APPROVED	10	TITLE	SCALE					
DE APPR.	-##-	BRACKET ASSEMBLY	1:2					
DATE 07 10 24 COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINATE AND COMPONENTIAL AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS								

3

DQA:		· · · · · · · · · · · · · · · · · · ·	Date:			WORK ORDER NON-CONFORMANCE / UPDATE							
QA Closed:	-		Date:			WORK ORDER HOR		J. 1. O.	With the property of		Vork Order up	date only	AEROSPACE
Work Order:						DISPOSITION							
Part No						Rework Scrap Use-as-is Suspected Unapproved		Machining Small Fa		Crosstube Small Fab Finishing Composite	Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
Root					Desci	ription of work order update	Ī	nitial	А	ction	Sign &		
Cause		Date Step Qty			or non-conformance	Chief		1		Date	Verification	n QC Inspector	
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved								. 9					
							FAL	JLT CAT	regory				
Landir			 ·			General						·······	
		Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter				Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set			Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Turning Sequence Wave/Twist in Tube					Finish Fit/Function		Out of Calibration Out of Sequence					

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DQA:		_ Date:											
QA Closed: Date:					WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only								
QA Closed. Date.							<u> </u>	·····		vvork Ord	ei up	date only	
Work Order:					DISPOSITION				/PROCESS				
					Rework				Water Jet	Engineering			
Part No.				Scrap	1		Skid-tube Machining	—		Prod. Eng. Coor.		Quality	
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NCR N	lo				Suspected Unapproved		Large Fab Comp			Supplier			1
						_			-				
Root				Descr	iption of work order update	1	Initial		ction	Sign			
Cause	Date	Step	Qty	<u> </u>	or non-conformance	Ch	nief Eng	Desc	cription	Dat	e	Verification	• QC Inspector
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Doc/Data													
Equip/Tooling						1							
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Material			ţ I										
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Offset/Setup													
Process													
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Transport													
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Landir	ng Gear				General		_		_				
	Bending				Bend		Folio/Program			Outside Dimensions		ensions	Pressure/Forced
	Centre Not Concentric				BOM/Route		Grain			Over/U	Over/Under tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ware		Part Inc	Part Incorrect		Temperature/Cure
	Crimp/Kink/Ripple/Wave				Burrs 👯		Inspect	ion Incomplete/L	complete/Unqualified		Part Lost/Missing		Weld
	Cuffs				Contamination		Instructions Incomplete/Unclear		/Unclear [Part Mo	Part Moved		Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		Positioned Wrong		Vrong	_
[Heat Treat				Cut Too Short		Mislabe	eled		Power	Power Loss/Surge		Other
	Inspection Strip in Tube				Drawing		Misread	d .	•			_	
[Marks/Chatter				Drill Holes		Off-set						-
[Turning 9	Sequence			Finish		Out of (Calibration					
	Wave/Twist in Tube				Fit/Function		Out of Sequence						